

Work Order ID 59445

Friday, June 04, 2010 11:24:17 AM



Page 1

Item ID: D5951

Accept



Setup Start



Revision ID:

Item Name: Saddle, 205

Stop



Start Date: 6/4/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: 14Date: 10-06-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D5951	Rev B

100



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

*MWC
10/06/21*
6 Ø

HAAS CNC vertical machine #1

 1-Machine as per folio D5951, Ensure Batch Number is entered
 2-Machine
 Keyway
 3-Deburr & Tumble

110



QC1- Inspect dimensions to dimension sheet

0.00

*MWC
10/06/21
10/06/22*
6 Ø

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

6 Ø 10/06/23
6 Ø

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59445

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Page 2

Item ID: D5951

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Item Name: Saddle, 205

Stop



Start Date: 6/4/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

6 BL10-6-23.

Hand Finishing

140



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M114841

Memo

0.00

START TIME:

2:10

OVEN TEMPERATURE:

320°

240

FINISH TIME:

6 BL10-6-23.

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

P10/24/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59445

Friday, June 04, 2010 11:24:17 AM



Page 3

Item ID: D5951

Accept



Setup Start



Revision ID:

Item Name: Saddle, 205

Stop



Start Date: 6/4/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



Packaging

Packaging

Operation
DescriptionIdentify as per dwg & Stock Location: *430*Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

*P.C.**10/4/24 (6)*

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

10/6/24 (8)

Memo

0.00

10/6/24 (8)

QC

10/6/24 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, June 04, 2010 11:24:22 AM

Page 1

Work Order ID: 59445



Parent Item: D5951



Parent Item Name: Saddle, 205

Start Date: 6/4/2010

Required Date: 6/10/2010

Comments: IPP Rev:E Re-Format 05-11-29 JLM
IPP Rev:E Re-Format 05-11-29 JLM

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-013		Manufactured	No			100	Each	20.0000	1	6			

Saddle Billet

Location	Loc Qty	Loc Code
MAT47	20	
46413	20	

6  10/06/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	59445
Description: Outer Fwd Saddle				Part Number:	D5951
Inspection Dwg: D5951				Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.437	0.444		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.753	1.756	1.750	1.750		
C	5.245	5.255		5.252	5.250	5.250	5.250		
D	6.995	7.005		7.003	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.747	4.750	4.750	4.750		
G	0.315	0.322		0.317	0.321	0.321	0.321		
H	1.522	1.532		1.524	1.527	1.527	1.527		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.582	4.580	4.580	4.580		
K	0.315	0.322		0.317	0.322	0.322	0.322		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.503	0.503	0.503	0.503		
N	1.615	1.635		1.631	1.632	1.632	1.632		
O	7.990	8.010		8.002	8.002	8.002	8.002		
P	2.240	2.260		2.253	2.245	2.245	2.245		
Q	0.307	0.312		0.309	0.310	0.310	0.310		
R	0.760	0.765		0.760	0.764	0.764	0.764		
S	0.490	0.510		0.507	0.501	0.505	0.503		
T	1.375	1.395		1.391	1.3815	1.382	1.390		
U	2.000	2.020		2.013	2.015	2.004	2.009		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: AMW / AMW
 Date: 10/06/23 / 10/06/23

Audited by: KJ / KJ
 Date: 10/06/23 / 10/06/23

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	<u>JLM</u>
E	08.04.21	Dimension E revised	KJ/DD	<u>DD</u>

DART AEROSPACE LTD				Work Order:	59445
Description: Outer Fwd Saddle				Part Number:	D5951
Inspection Dwg: D5951				Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.437	0.444		0.440	0.440				
B	1.745	1.755		1.750	1.750				
C	5.245	5.255		5.250	5.250				
D	6.995	7.005		7.000	7.000				
E	5.240	5.260		5.250	5.250				
F	4.745	4.755		4.750	4.750				
G	0.315	0.322		0.321	0.321				
H	1.522	1.532		1.521	1.521				
I	3.048	3.058		3.053	3.053				
J	4.575	4.585		4.580	4.580				
K	0.315	0.322		0.322	0.322				
L	0.495	0.505		0.500	0.500				
M	0.490	0.510		0.503	0.505				
N	1.615	1.635		1.632	1.632				
O	7.990	8.010		8.000	8.000				
P	2.240	2.260		2.245	2.245				
Q	0.307	0.312		0.310	0.310				
R	0.760	0.765		0.763	0.763				
S	0.490	0.510		0.499	0.507				
T	1.375	1.395		1.390	1.385				
U	2.000	2.020		2.010	2.005				
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>DJL</i>	Audited by:	<i>JK</i>
Date:	<i>10/06/22</i>	Date:	<i>10/06/23</i>

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	<i>JK</i>

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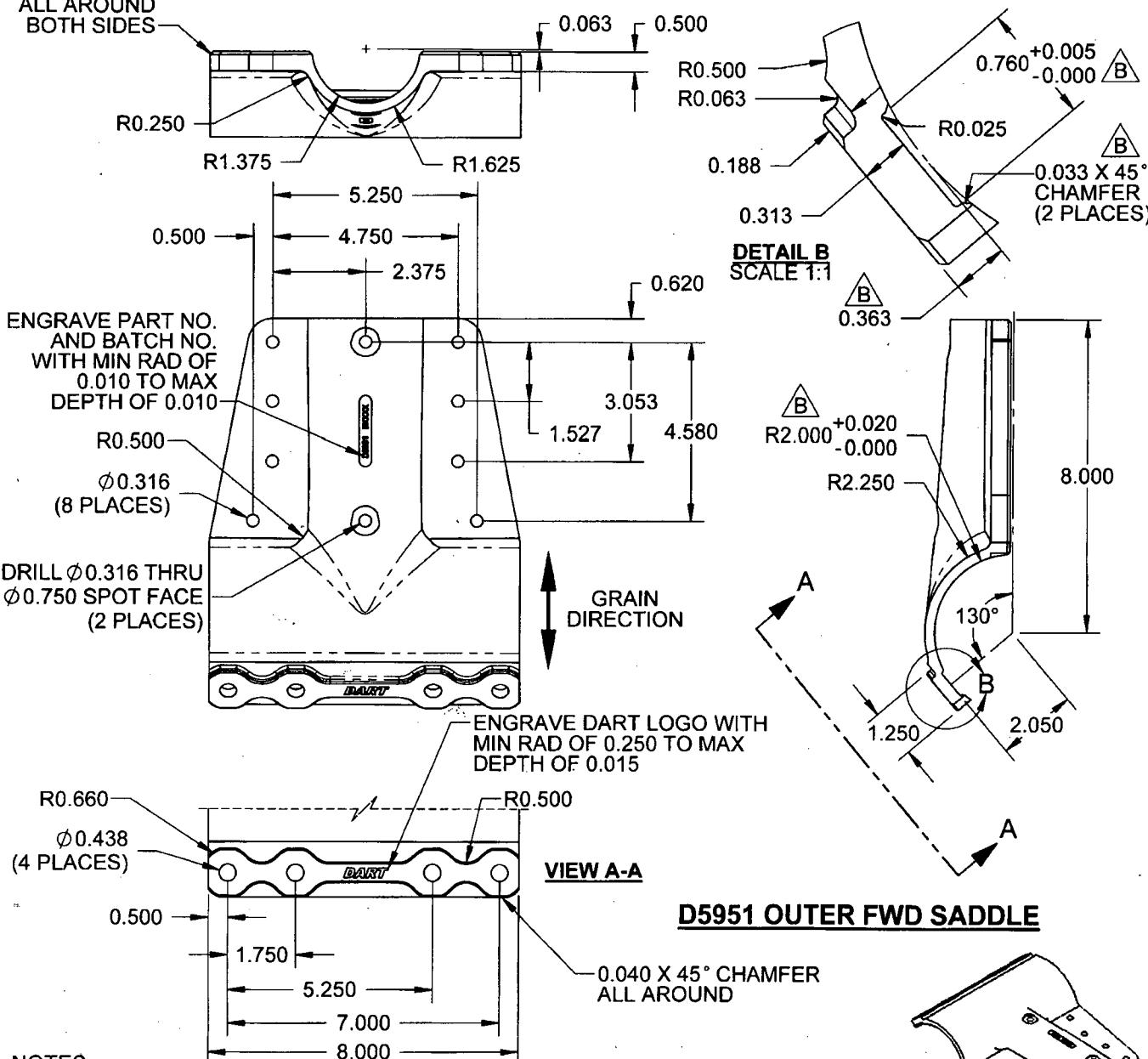
DART

סבון גוף

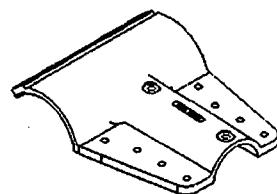
DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED CE	APPROVED <i>off</i>	DRAWING NO. D5951	REV. B	SHEET 1 OF 1
DATE 06.11.07	TITLE OUTER FWD SADDLE		SCALE	1:4

CHAMFER
0.075 X 45°

REV	DATE	DESCRIPTION
A	97.05.06	NEW ISSUE
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; ϕ 0.316 WAS ϕ 0.313; ADD TOLERANCE TO R2.000; ADD 0.363 DIM;



D5951 OUTER FWD SADDLE



ISOMETRIC VIEW
SCALE 1:8

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-013 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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